

Date: Thursday, 11/29/2007 11:01:03 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BO 105 SKID TUBE 'I' BEAM
Job Number : 36015	
Estimate Number : 11075	
P.O. Number : N/A	Part Number : D2976
This Issue : 11/29/2007 S.O. No. : N/A	Drawing Number : D2976 REV A1
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : LANDING GEAR	Drawing Revision : A1
Previous Run : 33545	Material : N/A
Written By : <u> </u>	Due Date : 12/5/2007 Qty: 2 Um: Each
Checked & Approved By : <u> </u>	
Comment : Est. C 02.10.30 Re-format KJ	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2963084	105 I Beam Extrusion
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Comment: Qty.: 4.5938 Each(s)/Unit Total : 9.1875 Each(s)

Extrusion 'I Beam' thin

Pick:

Qty Part Number Description Batch

1 D2963-084 Extrusion

Handwritten: DP 7-11-30

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

Cut D2963-084 extrusion to length: (82.00")

Use Jig DT8546 to drill pilot holes

Open holes to finish size per dwg D2976

Deburr

Handwritten: DP 7-11-30

3.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

Handwritten: DP 7-11-30

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

Handwritten: BE 07-11-30

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 46

Handwritten: DP 7-11-30

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/12/04

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BO 105 SKID TUBE 'I' BEAM

Job Number: 36015

Part Number: D2976

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



2

Comment: FINAL INSPECTION/W/O RELEASE

12/12/04

Job Completion



W. Adley

11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

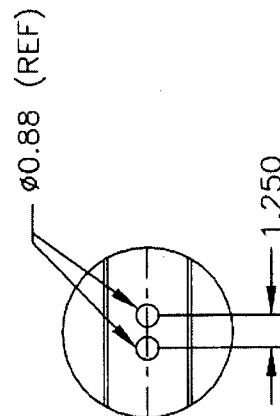
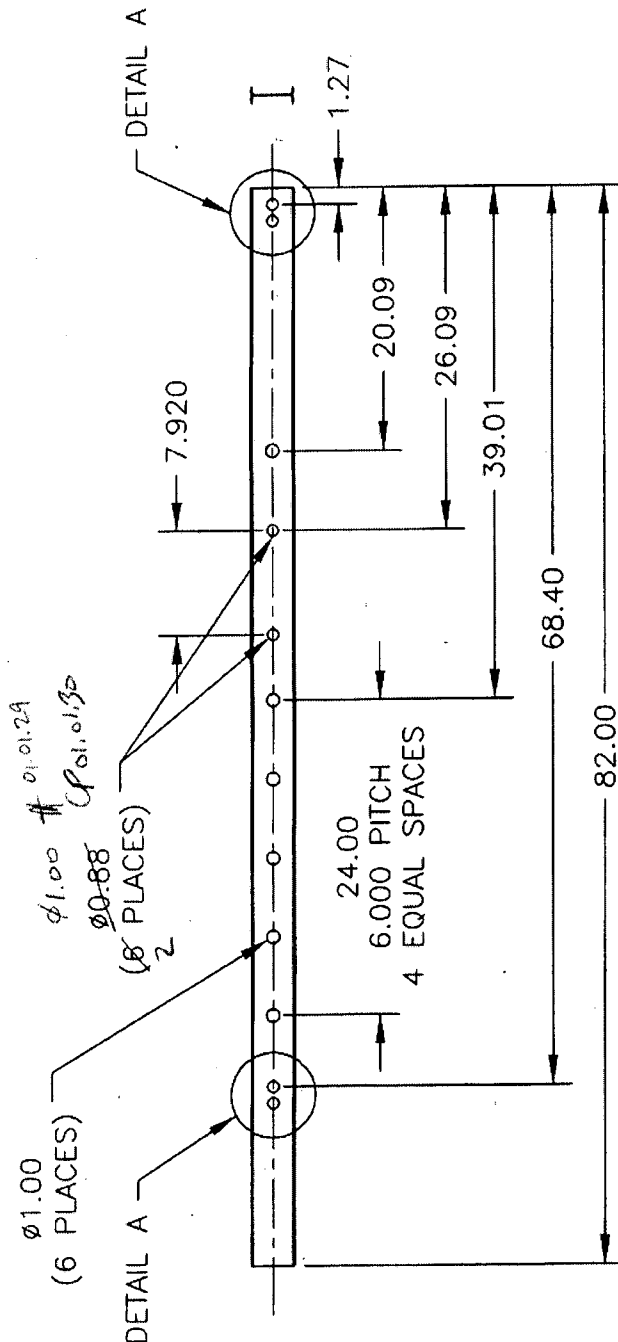
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN RF	DRAWN BY RF	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED #	APPROVED #	DRAWING NO. D2976	REV. A SHEET 1 OF 1
DATE 00.03.14		TITLE WEB	SCALE 1:14
A	00.03.14	NEW ISSUE	
A1	01.01.29	OPEN GROUND HANDLING HOLES TO $\phi 1.00$	

RELEASED
00.05.11 #



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36015

MAKE FROM D2963-084 EXTRUSION
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018, UNLESS OTHERWISE NOTED

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